



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D407-667-205
Job Sheet 179374



Part No: D407-667-205

Job Qty: 1 ea

Part Name: Aft Crosstube - High 407



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/18/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV G IPP Rev:C 05.09.02 Add holes for comp. w/ Bell Skids KJ/JLM IPP Rev:D Add Magnobond,Rubber Cushion,Clamps 07-02-19 JLM IPP Rev:E 08-05-22 add comment seq. 6 & QC15 & QC5 DD verf:EC IPP Rev:F 08-06-12 add comment seq. 24 DD verf:EC IPP Rev:G 08-08-19 revE per dwg DD verf:EC IPP Rev H 09.01.06 ECN 08-562 EC verf:DD IPP Rev:I 10.04.07 revise route seq. in born DD verf:JLM IPP Rev J 11.04.26 removed abrasion strip ecn 11-551 EC verf:DD IPP REV:K 11.10.03 DEOD407-667-245-F-2 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Stores/Pkg-1		DP 7/8/21/18
110	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-4		DP 7/8/21/18
120	CNC Bend Skidtubes	1 pcs	7/6/18	7/6/18	1.99	3.33	CNC Bend Skidtube		DP 7/8/21/18
130	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC15		
140	Crosstubes	1 pcs	7/6/18	7/6/18	0.00	3.47	Crosstubes-2		DP 7/6/2018-08-23
150	HandFXtube	1 pcs	7/6/18	7/6/18	0.00	0.91	HandFinish5		GP 18-08-23
160	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC7-3		
170	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC5		
180	Outsource	1 pcs	7/6/18	7/6/18			SKY002-VC	2	
190	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging2		SEP 13 2018
200	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC6		
210	SprayPaint	1 pcs	7/6/18	7/6/18	0.00	1.39	Spray Paint		SEP 18-10-23
220	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC14		AS 18-11-9
230	Crosstubes	1 pcs	7/6/18	7/6/18	0.00	3.47	Crosstubes-2		SA 18/11/09
240	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC5		38
250	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-4	DAS	NOV 28 2018
260	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC4	69	
265	DC	1 pcs	7/6/18	7/6/18	0.00	0.00	DC	8-89	NOV 29 2018
270	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-2		
280	QC21-FG	1 Ea	7/6/18	7/6/18	0.00	0.00	QC21		NOV 29 2018

Part Op 120 - 1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio 21

Descriptions: 140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D407-667-245. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes. Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 5-Drill aft rivet holes using drill Jig DT8787 aft as per Dwg D407-667-245. Drill only the top (2) holes. 6- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint. 8-*** WEAR LATEX

GLOVES WHEN HANDLING CROSSTUBE***Debur & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

150 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 0380

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside and outside crosstube as per DEO D407-667-245 and QSI 005 4.2 ***Mask underside of crosstube as shown*** 3- Apply clear coat as per dwg Clear Coat Batch: 138832 Prime 138962 Paint 138956

220 - Then,Wrap in plastic bag to protect from scratches

230 - 1- Install chafing shield as per D407-667-245 using DT10096 to establish 8.90 dimention.Top holes should be facing up. ****Ensure chaffing is to be position "overlap" AFT**** A/R Proseal 890 Batch: 5096394 EXP: 3/19 2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 3-Instali support with Scotch-Weld DP460 and install clamps as per Dwg D407-667-245 using installaiton jig DT9025. Torque clampsas per dwg A/R Scotch-Weld DP460 Batch: 8064031 EXP: 4/19. ***LET CURE FOR 24 HOURS*** CURE TIME: START: 18/10/17 FINISH: 18/10/10 4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

240 - ***RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURE FOR 24HOURS AS PER DWG DEO***

265 - Photocopy bluefile and create labels as per PPP D407-667-205 CHG009

270 - Identify and in kanban rack

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D407-667-205TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2873-045	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2894-1	2.75 Support	1 Ea (1 ea)	230-Crosstubes	
D3190-1	Chaffing Shield	2 Ea (2 ea)	230-Crosstubes	
D3595-063-430	Rubber Cushion 0.63" Wide X 4.30" Long	2 Ea (2 ea)	230-Crosstubes	
MS20601-AD4W8	Rivet	14 Ea (14 ea)	230-Crosstubes	
MS21920-22	Clamp	4 Ea (4 ea)	230-Crosstubes	
MS21920-25	Clamp	2 Ea (2 ea)	230-Crosstubes	
NAS1149D0563J	Washer	18 Ea (18 ea)	230-Crosstubes	5050053
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging	5081283
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging	5058983-1
AN5-34A	Bolt	4 Ea (4 ea)	250-Packaging	5091410
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging	5093562

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 5091098	D407-667-205TRN	1	0	0
230-Crosstubes	D2873-043 5090584	2	19	0
	D2873-045 5050682	2	23	0
	D2894-1 5054564	1	10	0
	D3190-1 1394928	2	69	0
	D3595-063-430 5074327	2	40	0
	MS20601-AD4W8 5066928	14	228	0
	MS21920-22 5105481	4	66	0
	MS21920-25 3107731	2	140	0
	NAS1149D0563J	18	1,979	0
250-Packaging	AN5-10A	10	151	0
	AN5-32A	4	390	0
	AN5-34A	4	89	0
	MS21042L5	4	583	0

Part Specifications

DART
AEROSPACE

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1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

it be found.

Plex 6/18/18 12:47 PM Dart.lajeunesse.marie

Container No: S103902



Part: D407-667-205

Job No: 179374

Serial No/Batch: S103902

Revision:

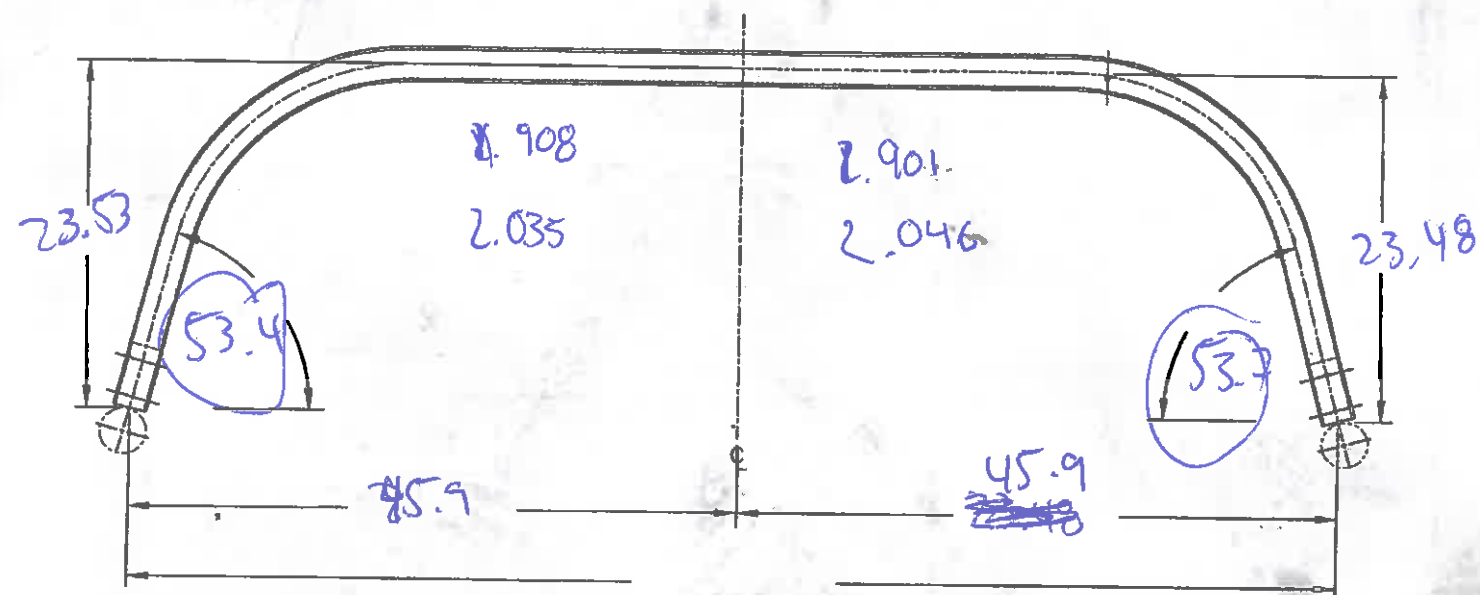
Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAI

DART AEROSPACE LTD		Work Order: 1791374
Description: Crosstube High Aft (407)		Part Number: D407-667-205
Inspection Dwg: D407-667-245	Rev: G	Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	45.79	46.05
Angle	54	56
Total Span	91.58	92.100
Bending Passes	6	--
Crushing	--	6%



	Side A	Side B
Bending Passes	27	27
Crushing	3.2%	3.7%
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.22	Dwg Rev updated	KJ	
C	11.08.22	Dimensions updated	KJ	
D	11.09.30	Dimensions updated	KJ	
E	12.04.16	Added bending, crushing dimensions	KJ	
F	15.05.14	Dwg Rev updated	KJ	

Item	QTY	PART NUMBER	DESCRIPTION
	245		
	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
1	1	D8011-115	CROSSTUBE
2	2	D2873-043	NUT PLATE
3	2	D2873-045	NUT PLATE
4	1	D2884-1	SUPPORT
5	2	D3190-1	CHAFING SHIELD
6	2	D3585-063-430	RUBBER CUSHION
7	14	MS20801AD4W8	RIVET (OR NAS9302B 4-8)
8	4	MS21920-22	CLAMP
9	2	MS21920-25	CLAMP (OR MS21920-24)
10	AR	SCOTCH-WELD DP480	EPOXY ADHESIVE, 3M SCOTCH-WELD
11	AR	PROSEAL 880	SEALANT

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D8011-115
FINISHED LENGTH = 112.91±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT CROSSTUBE PER DART QSI 005 4.2
FOR HATCHED AREAS (ZN A6-2), MASK AS REQUIRED
TO APPLY PRIME AND APPLY CLEAR COAT ONLY
TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART: BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2884-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP480 PER QSI 016. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS WITH D3585-063-430 RUBBER CUSHIONS TO SECURE D2884-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.008" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- APPLY A THIN COAT OF PROSEAL 880 ON INSIDE CONCAVE SURFACE OF D3190-1 CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEAL D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 880 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS 90 TO 70 DEGREES FROM BOTTOM OF CROSSTUBE OPPOSITE D2884-1 SUPPORT.
- TORQUE CLAMPS 80 TO 100 IN-LB. TORQUE CLAMPS ON D3190-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

RELEASED

2015 APR 09
97 15:557

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 179274 M05
1806-18

G	INCORP. DEOS D407-667-246-F1/F2 (ZN D8-1, A6-1, D5-2, B6-2, C8-2); 8.90 WAS 8.53 (ZN D5-2); TORQUE REDUCED FOR CHAFING SHIELD (ZN A6-1); FINISH REVISED TO ALLOW MANUFAC. FLEXIBILITY (ZN C8-1)	RF	13.03.20
F	REFORMAT NOTES TO NEW STANDARDS (ZN B6-1); RELOCATED FLAG # 6 (ZN A6-3) PER NCR 240; REMOVED REF. & ADD TOLERANCES (ZN C8-3, C4-3 & D2-3)	RF	06.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.80 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR98B-21 AND ECR#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F. REMOVE -861 ABRASION STRIP, ADD MAGNABOND 6388, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT1AA SKID TUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	D407-667-246		REV. G
APPROVED	97		SHEET 1 OF 4
DE APPR.	97		SCALE
DATE	15.03.20		CROSSTUBE ASSY (407 HIGH AFT)
			NTS

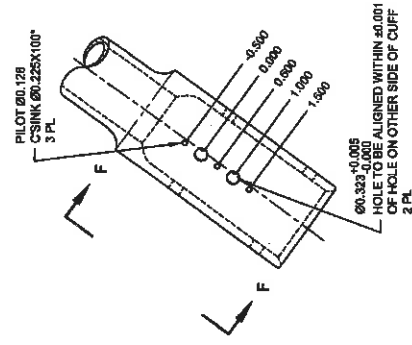
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. G
SHEET 1 OF 4

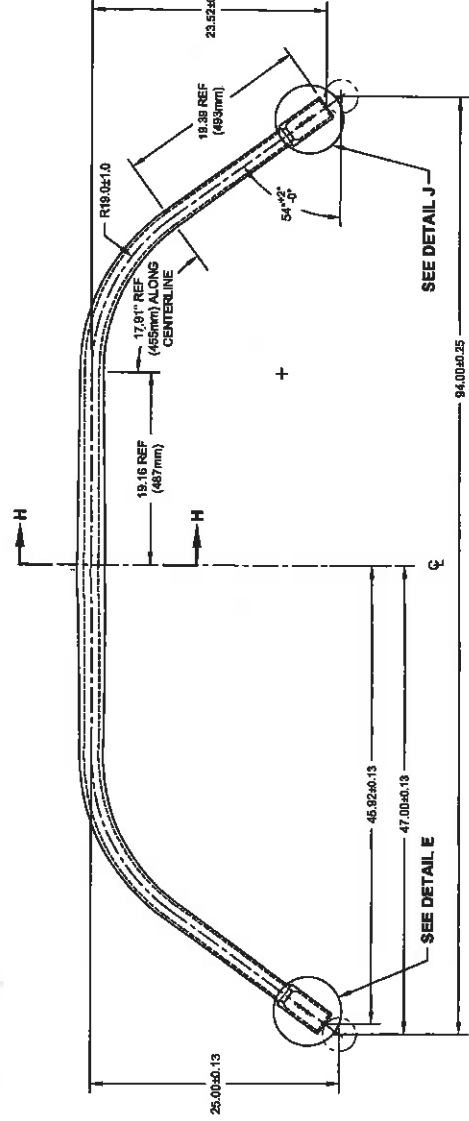
CROSSTUBE ASSY (407 HIGH AFT)

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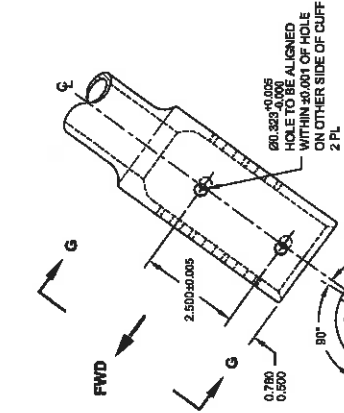


DETAIL E
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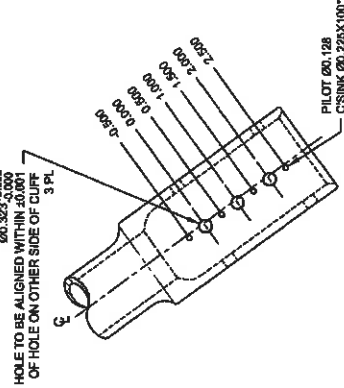


D407-667-605
BENDING AND DRILLING DETAIL
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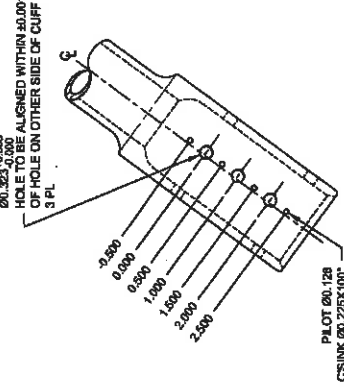
DETAIL J
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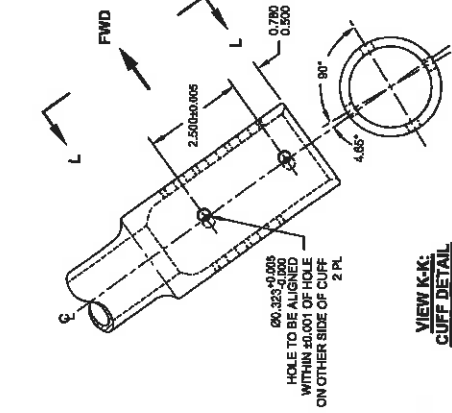
VIEW F-F:
CUFF DETAIL



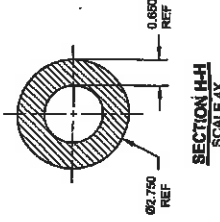
VIEW G-G
(VIEW LOOKING AFT, ROTATED)



VIEW L-L
(VIEW LOOKING AFT, ROTATED)



VIEW K-K:
CUFF DETAIL



SECTION H-H
SCALE 4X

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2015 APR 09

DESIGN	DRAWN	CHECKED	MFG. APPR.	APPROVED	DATE	15.03.20
RF	RF	RF	RF	RF		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
DRAWING NO. D407-667-245						REV. G
TITLE CROSS-TUBE ASSY (407 HIGH AFT)						SHEET 3 OF 4
SCALE NTS						
DATE 15.03.20						

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER
PO040976

Supplier: SKY002-VC Skyservice 6120 Midfield Road Mississauga ON L5P 1B1 Canada Phone: 905-678-5636 Fax: 905-678-5841	PO No: PO040976 PO Date: 9/11/18 Due Date: 9/13/18 Purchase Order Revision: Revision Date: Ship-To Contact: Lavoie, Chantal Phone: clavoie@dartaero.com
Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	Via: Ground Pynt Terms: Net 30 Freight Terms: Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180615	D4464-041	Fuel Tank Assembly : Various STC's ISSUE P/O LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
2	178952	D407-667-205	Aft Crosstube - High 407 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 0380	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
179372			SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
179373			SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
179374			SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
181961			SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
181962			SEP 13 2018	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
Sub Total:							6	0	6		\$697.06

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO040976

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	174618	D350-748-101	FWD Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 Issue P/O: Stress relief at 375degree for 5hrs Magnetic Particle Inspect per ASTM E1444 Cad Plate per AMS-QQ-P- 416B, Class 1, Type 2 Embrittle relief at 375 defree for 8 hrs, Chromate Treat C of C req'd	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174634	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174639	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174642	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174643	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
Sub Total:							5	0	5		\$580.88
4	174673	D350-748-201	Aft Crosstube AS350 / AS355 : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO METCOR: AFTER BENDING: STRESS RELIEF AT 650° F ± 25° F FOR A MINIMUM OF 2 HRS AIR COOL TO AMBIENT TEMPERATURE note: crosstube made from 4130 seamless steel tube DETAIL C OF C REQUIRED	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174674	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	174676	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	181140	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
	181141	1	X	Firmed	-	9/13/18	1 pcs	0 pcs	1 pcs	\$116.17647/pcs	\$116.18
Sub Total:							5	0	5		\$580.88



Dart Aerospace Ltd.

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PURCHASE ORDER

PO040976

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$1,975.00

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

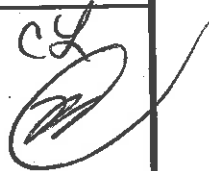
A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Plex 9/13/18 7:53 AM dart.lavoie.chantal



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SUBCONTRACT SHIPPER

SUBCONTRACT SHIP TO

Ship To: Skyservice
6120 Midfield Road
Mississauga, ON L5P 1B1 Canada
Phone: 905-678-5636 Fax: 905-678-5841

SHIPPER

Shipper No: 614
Shipper Date: 9/13/18
Carrier: *
Ship Via:
Vehicle Reg:
Note:
Freight Terms:

Part Information

Part No: D350-748-101
Cust Part No: D350-748-101
Reference No:
Part Information Note: DWG REV H IPP Rev:A New Issue 06-07-05 JLM
IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
VERIFY BY:DD IPP Rev:C Rev B 07-11-15 DD IPP
Rev D Combined manufacturing 08.04.02 EC verified
by: DD IPP Rev:E 08-06-24 revD as per dwg DD
verified by:EC IPP Rev:F 10.08.04 added QSI010 4.3
DD ver:EC IPP REV:G ADD UNDER BEND
COMMENT 12-05-28 JLM IPP REV:H 12.11.05 as
per dwg D350-748-141G DD ver:JLM IPP REV:I
15.03.19 as per dwg D350-748-141revH dd ver:jlm
Drawing No:
Program:
Program Customer:
Addl Docs:
Commercial: Product Line: Crosstube - High
Primary OEM Application: Airbus
Manufacturer: DART
Advertised on web?: No
Shipping Dims & Weights: Metric: L2.29m x W0.86m x
H0.18m,Actual Weight of 26.31 kg
Shipping Dims & Weights: Imperial: L90" x W34" x
H17",Actual Weight of 58 lbs
Name: FWD Crosstube AS350 / AS355
Product Family: Landing Gear
Piece Weight: 0 lbs
Alloy Type:
Alloy - Temper: -
Description: TC STC SH06-27 Issue 2, FAA STC SR02359NY
11/03/04, EASA STC EASA.10016903 Revision 2
10/09/03, BRAZIL 2009S04-04 09/04/06
Quantity:

OPERATION

Operation: Outsource - 174

Description: ISSUE P/O TO SKYSERVICE:

Note:

DETAIL

Part	Operation	PO	Job	Container	Heat Code	Net Weight (lbs)	Gross Weight (lbs)	Quantity
D350-748-101 09/20/2017 LMC Can Only Be Sold To AVIC. Discontinued And Replaced By D350-748-103. Oversized Item, Please Refer To Shipping Instructions.	Outsource ISSUE P/O TO SKYSERVICE:	PO040976	174634	S093239		0	0	1
				174639	S093544	0	0	1
				174642	S093602	0	0	1
				174618	S093751	0	0	1
				174643	S093762	0	0	1
D350-748-201 09/20/2017 LMC Can Only Be Sold To Avic. Discontinued And Replaced By D350-748-203.	Outsource ISSUE P/O TO SKYSERVICE:	PO040976	174673	S094573		0	0	1

9/13/2018 Oversized Item, Please Refer To Shipping Instructions.		[Dart Hawkesbury] Subcontract Shipper - Lavoie, Chantal							
			174674	S094587		0	0		1
			174676	S094598		0	0		1
			181140	S095319		0	0		1
			181141	S095366		0	0		1
D407-667-205 09/20/2017JR Oversized Item, Please Refer To Shipping Instructions.		Outsource *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 0380	PO040976	181961	S103098		0	0	1
			178952	S103104		0	0		1
			179373	S103183		0	0		1
			179372	S103185		0	0		1
			181962	S103187		0	0		1
			179374	S103902		0	0		1
D4464-041 09/20/2017JR D4464-041 Aux Fuel Tank Reservoir (Ref. D350-794-141) Is About 0.25" Longer Than The D4055-041 Aux Fuel Tank Reservoir (Ref. D350-794-041); Please Contact Technical Support For More Details (Ref.: Case 9383).		Outsource ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	PO040976	180615	S100152		0	0	1
			Total		17		0	0	17

Driver Signature

Customer Copy

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**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37372	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO040976
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

1 FUEL TANK , P/N# D4464-041 , J/S# 180615 ✓

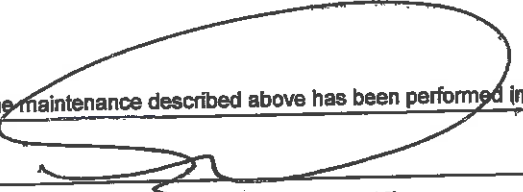
6 AFT CROSSTUBES , P/N# D407-667-205 , J/S# 181961 , 181962 , 179372 , 179373 , 179374 , 178952 ✓

5 FWD CROSSTUBES , P/N# D350-748-101 , J/S# 174618 , 174639 , 174642 , 174643 , 174634 ✓

5 AFT CROSSTUBES , P/N D350-748-201 , J/S# 174673 , 174674 , 174676 , 181140 , 181141 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16						SEP 11 2018	
3 LEAKS FOUND IN FUEL TANK							
REMAINING ITEMS: NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: SEP 11 2018
Name: RAFIK MELIKIAN		